

Work Order ID 58406

May 6, 2010 8:09:44 AM



Page 1

Item ID: D2327-3

Accept



Setup Start



Revision ID:

Item Name: Spacer Bushing

Stop



Start Date: 06/05/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

10-5-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2327	Rev D								
100		0.00							
	Hardinge CNC LATHE SMALL					<i>20</i>	<i>0</i>		
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Turn per Folio FA232 and Dwg D2327 <input type="checkbox"/> Debur								
		<i>SA 10/05/10</i>							
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB					<i>20</i>	<i>0</i>		
QC	Memo	0.00							
Quality Control									
		<i>SA 10/05/10</i>							
120		0.00							
	QC8- Inspect parts - second check					<i>20</i>			
QC	Memo	0.00							
Quality Control									
		<i>SA 10.5.11</i>							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58406

May 6, 2010 8:09:44 AM



Page 2

Item ID: D2327-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer Bushing

Start Date: 06/05/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

*Badlot Call**10/05/20**20x*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/05/21**ME**10-5-20*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

May 6, 2010 8:09:48 AM

Page 1

Work Order ID: 58406

Parent Item: D2327-3

Parent Item Name: Spacer Bushing

Comments: IPP F05.11.02 Removed 303 SS KJ/EC

Start Date: 06/05/2010

Required Date: 13/05/2010

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	30.7400	0.1563			



304 ROUND BAR 0.375



Location

Loc Qty

Loc Code

MAT

12.1

111323

0

114467

12.1

MAT029

18.64

113325

3.85

114356

14.79

5.2 Rt SH 10/05/10

W/O:		WORK ORDER CHANGES					
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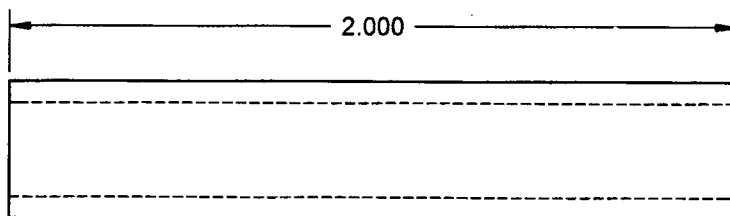
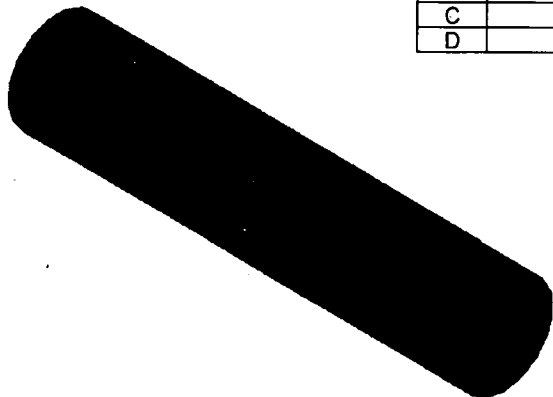
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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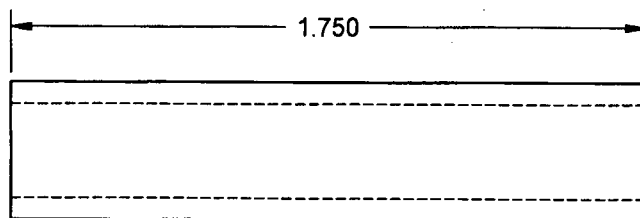
NOTE: Date & initial all entries



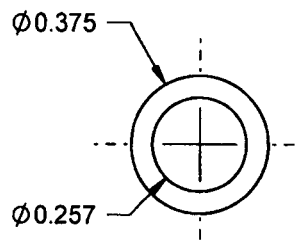
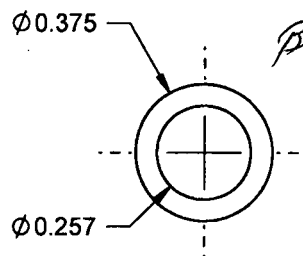
DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED CH	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING



RELEASED

06.11.14

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 582106

BS10-5-06

NOTES:

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING
(REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX



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